

slip July 5 to 12 best

Work Order ID 103814

103814

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June-28-13 1:42:16 PM

Item ID: D4785-041 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Long Basket Base Assembly, LH/RH
Start Date: 6/28/13 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 7/08/13 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: V Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4785	B

100 Weld per dwg A/R S.S. rod Batch: 124816 0.00
Large Fab
Memo 0.00
1- Use DT9610A to assemble contour ribs and the (2) D3916-5 ribs, weld as per dwg D4785
inspect before welding mesh
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D4785 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D4785
take lid to locate hinge and bracket
4- Weld D4672-1 blanking plates as per dwg

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
Memo 0.00
Quality Control

PC 13.7.3
1x
13.07.03

13.07.05
DAS
09
89

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 Item Name: Long Basket Base Assembly, LH/RH
 Start Date: 6/28/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/08/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						13-07-05	DAS 09 2-89
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00						lv & JH 12/07/05	

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Item ID: D4785-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long Basket Base Assembly, LH/RH
 Start Date: 6/28/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/08/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 9:30

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:05

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1X of m/f 13/07/05

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

14 of M 13/07/05

M125620

Work Order ID 103814

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Item ID: D4785-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long Basket Base Assembly, LH/RH
 Start Date: 6/28/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/08/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Assemble as per dwg Memo <i>M.D.</i> Pick kit and assemble	0.00 0.00							
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>wlo</u> Memo	0.00 0.00							

Handwritten: 12/02/07

Handwritten: DAS 05 13-07-05

Handwritten: D4785-041 / 13103382 x1 12/13/07

June-28-13 1:42:16 PM

Item ID: D4785-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/28/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/08/13 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

RB-07-8

Picklist Print

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Page 1

Work Order ID: 103814

Parent Item: D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/28/13

Required Date: 7/08/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.14 NEW ISSUE DD VERF:JLM
rev.pb1 DD VERF:JLM

IPP REV:B 13.06.17 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D4785-117 Rib Assembly		Manufactured	No			100	Each	0.0000	2	2		CC 13-7-4	
* D4785-1 Rib		Manufactured	No			100	Each	0.0000	2	2		CC 13-7-4	
* D4785-115 Rib Assembly		Manufactured	No			100	Each	0.0000	4	4		CC 13-7-4	
* D4785-3 Rib		Manufactured	No			100	Each	0.0000	1	1		CC 13-7-4	
* D4785-5 Rib		Manufactured	No			100	Each	0.0000	2	2		CC 13-7-4	
* D4017-7 Rib		Manufactured	No			100	Each	9.0000	1	1		CC 13-7-4	

Location

Loc Qty

Loc Code

WA005

9

100413

5

69730

1

82969

1

85435

1

88392

1

D4034-041

Manufactured

No

100

Each

8.0000

1

1

Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA004

4

100300

4

WA005

4

100301

3

84048

1

Picklist Print

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Page 2

Work Order ID: 103814

Parent Item: D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/28/13

Required Date: 7/08/13

Start Qty: 1.00

Required Qty: 1.00

✓ D4034-043
Fwd Upper Rib Assembly

Manufactured No

100 Each 7.0000

1 B103421 CC 13-7-4

Location	Loc Qty	Loc Code
WA004	3	
100287	3	
WA005	4	
100288	2	
82980	2	

✓ D3916-5
Light Rib

Manufactured No

100 Each 16.0000

2 2 CC 13-7-4

Location	Loc Qty	Loc Code
WA004	11	
100439	3	
94698	2	
99741	6	
WA005	5	
77142	1	
82933	4	

✓ D3913-1
Rib

Manufactured No

100 Each 3.0000

1 1 CC 13-7-4

Location	Loc Qty	Loc Code
WA004	2	
94721	1	
97735	1	
WA005	1	
88637	1	

DA D 4793-1 → 3 QTY → B 103827 → CC 13-7-3 *

SA S 4793-3 → 1 QTY → B 103828 → CC 13-7-3 *

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Shop Packet Print

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Work Order ID: 103814

Parent Item: D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/28/13

Required Date: 7/08/13

Start Qty: 1.00

Required Qty: 1.00

D3913-3
Rib

Manufactured No

100 Each 5.0000

1 1

CC 13-7-4

Location Loc Qty Loc Code

WA004

3

100444

2

97728

1

WA005

2

69160

1

84651

1

1x

D3913-9

Hinge Rib

Manufactured No

100 Each 8.0000

1 1

CC 13-7-4

Location Loc Qty Loc Code

WA005

8

100304

2

100788

5

70138

1

1x

D4016-1

Hinge Half, Base

Manufactured No

100 Each 44.0000

3 3

CC 13-7-4

Location Loc Qty Loc Code

WA004

41

100265

30

102322

11

WA005

3

94481

3

3x

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Work Order ID: 103814

Parent Item: D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/28/13

Required Date: 7/08/13

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

1,349.0406

33

33

CC 13-7-4

Expanded Metal Flat SS

Location

Loc Qty

Loc Code

MAT

176.2791180

125113

176.279118

WA

209

125457

209

WA007

963.761526

123448

15.96

125457

4.691526

125605

480

M126052

463.11

33.

D4020-11

Manufactured

No

100

Each

3.0000

2

2

CC 13-7-4

End Mesh, Basket

Location

Loc Qty

Loc Code

WA007

3

81442

2

84972

1

B 102072 → (2)

D3913-15

Manufactured

No

100

Each

9.0000

1

1

Wide Handle Plate

Location

Loc Qty

Loc Code

WA003

4

WA004

4

97719

5

97719

5

(1X)

Pl 13.7.3

D4021-1

Manufactured

No

100

Each

57.0000

3

3

Handle Plate

Location

Loc Qty

Loc Code

WA004

57

100366

47

100649

7

94596

3

(3X)

Pl 13.7.3

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Page 5

Work Order ID: 103814

Parent Item: D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/28/13

Required Date: 7/08/13

Start Qty: 1.00

Required Qty: 1.00

D4021-5
Blanking Plate

Manufactured No

100 Each 23.0000

2 2

11.10.13-07-5

Location	Loc Qty	Loc Code
GA	2	
100249	2	
ST084	21	
100249	13	
100737	6	
85065	2	

2x

D2581
Mounting Bracket

Manufactured No

100 Each 64.0000

2 2

CC 13-74

Location	Loc Qty	Loc Code
WA004	64	
101383	2	
103100	48	
70766	2	
81253	1	
82506	2	
83230	3	
85452	2	
87706	2	
99837	2	

2x

D2931
Bumper

Manufactured No

150 Each 2,168.0000

2 2

11.10.13-07-5

Location	Loc Qty	Loc Code
GA	170	
46064	170	
ST021	1998	
86435	1998	

2x

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Work Order ID: 103814

Parent Item: D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/28/13

Required Date: 7/08/13

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No

150 Each 518.0000 6

⑥ m.d. 13-07-5

Location	Loc Qty	Loc Code
ST351	4	
124221	3	
124858	1	
ST512	14	
122800	14	3x
ST513	500	
m125709	500	3x

MS20600-AD4W3 Purchased No

150 Each 939.0000 2 2

m.d.

Location	Loc Qty	Loc Code
ST311	806	
122151	4	
122452	4	
123525	294	
124231	504	2x
WA003	133	
107939	133	

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Work Order ID: 103814

Parent Item: D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/28/13

Required Date: 7/08/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

3,647.0000

6

6

7.10.13-07-5

Nut

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

1903

111668

1

117885

32

119017

55

119075

138

123265

43

M126036

1634

6x

ST506

1723

123900

954

124291

769

NAS1149DN832J

Purchased

No

150

Each

761.0000

2

2

7.10.13

Washer

Location

Loc Qty

Loc Code

ST293

761

123603

361

124555

400

2x

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Work Order ID: 103814
 Parent Item: D4785-041
 Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 6/28/13
 Start Qty: 1.00

Required Date: 7/08/13
 Required Qty: 1.00

NAS1149F0332P Purchased No

150 Each 10,608.000 12 12

11.10.13-07-5

Washer

Location	Loc Qty	Loc Code
GA	182	
122063	182	
ST294	158	
122063	158	
ST295	3	
123352	3	
st510	5265	
123900	5265	
ST510a	5000	
125646	5000	

12x

D4672-1 Manufactured No

150 Each 6.0000 2 2

CC 13-7-4

Blanking Plate

Location	Loc Qty	Loc Code
WA004	2	
101186	2	
WA005	4	
88253	4	

B100819 → (2x)

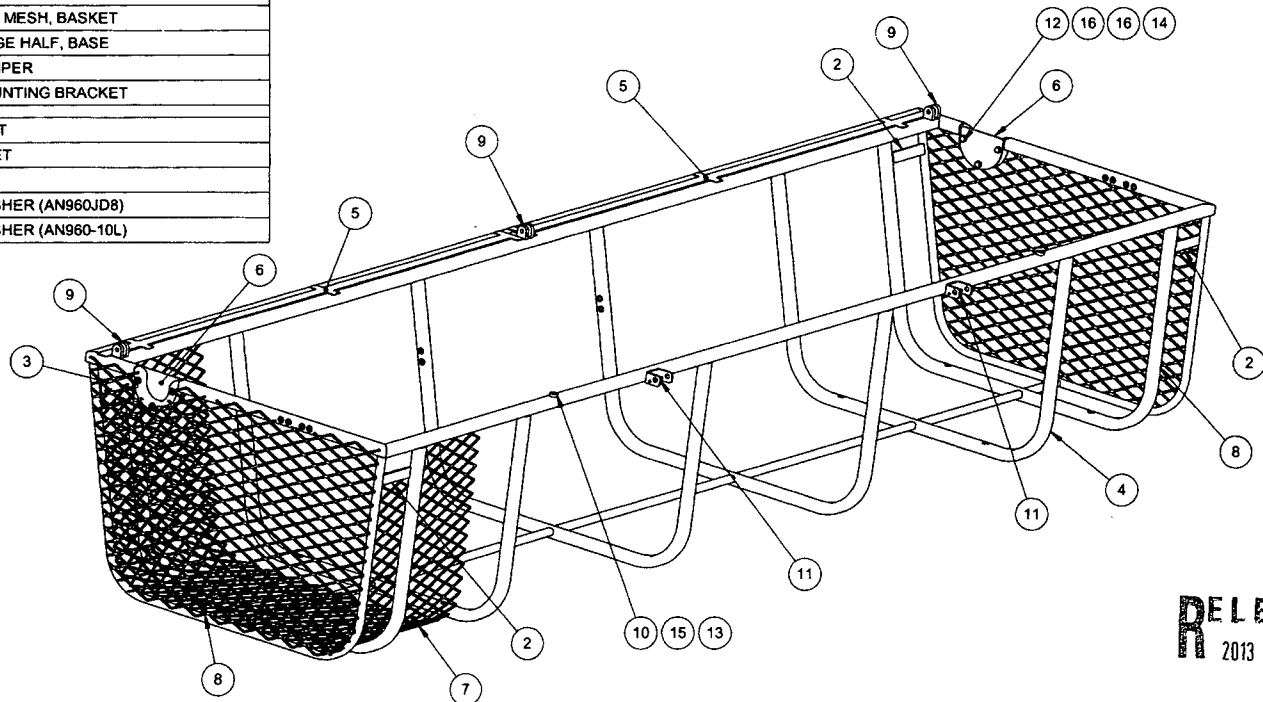
June-28-13 3:00:44 PM

Shop Packet Print

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w/o 103814

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)



D4785-041 LONG BASKET BASE ASSY, LH/RH

NOTES:

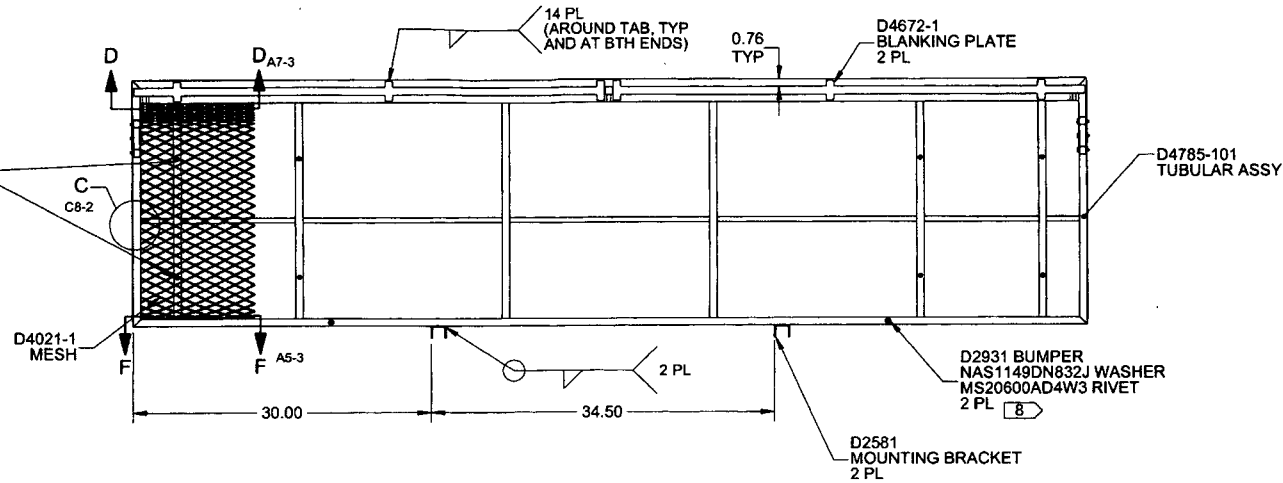
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2013-06-20

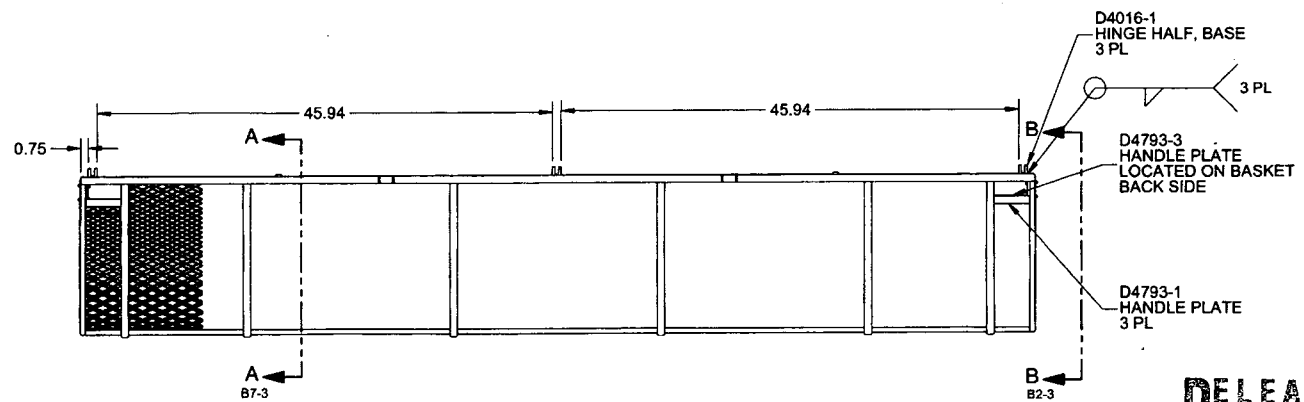
B	REPLACE D3916-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D4785 REV. B	
CHECKED	<i>JS</i>	SHEET 1 OF 7	
MFG. APPR.	<i>JS</i>	TITLE LONG BASKET BASE ASSY SCALE NTS	
APPROVED	<i>JS</i>	DATE 13.06.11	
DE APPR.	<i>JS</i>	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR BUSHINGS
TYP



DETAIL C D7-2

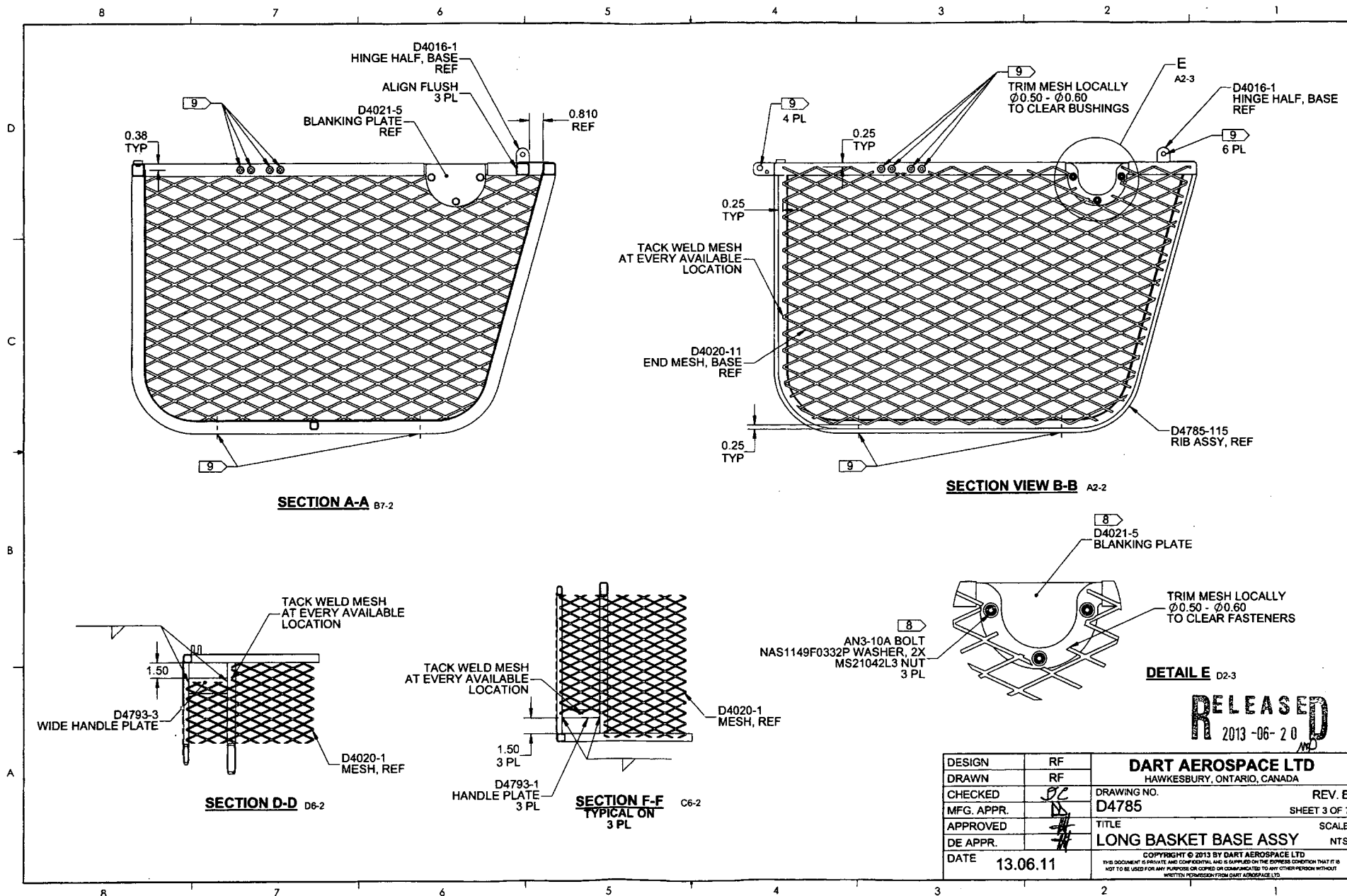


D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

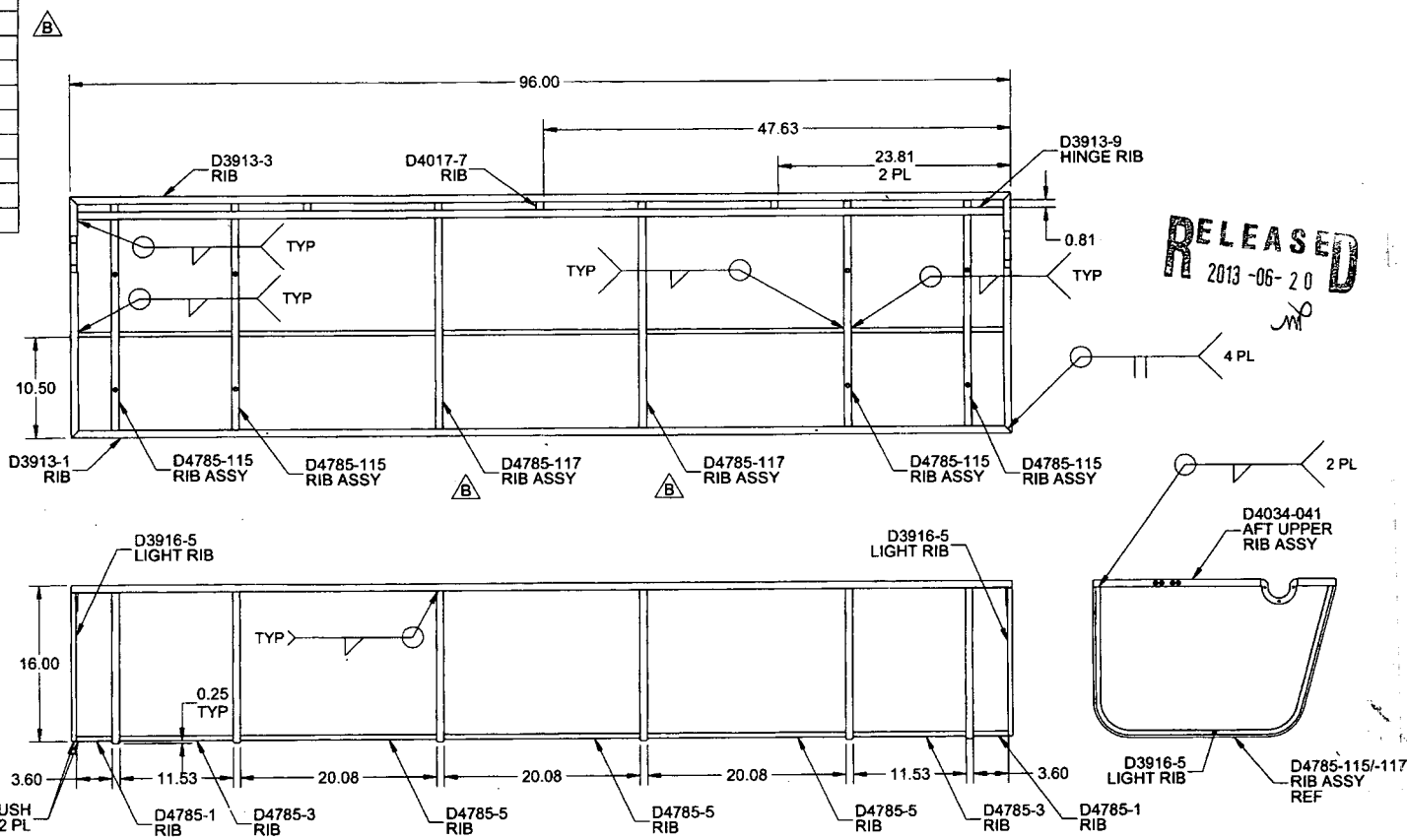
RELEASED
2013-06-20
JW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	IS	D4785	SHEET 2 OF 7
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4785-101	TUBULAR ASSEMBLY
2	2	D4785-1	RIB
3	3	D4785-5	RIB
4	4	D4785-115	RIB ASSEMBLY
5	2	D4785-117	RIB ASSEMBLY
6	2	D4785-3	RIB
7	3	D4017-7	RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY
10	2	D3916-5	RIB, LIGHT
11	1	D3913-1	RIB
12	1	D3913-3	RIB
13	1	D3913-9	HINGE RIB

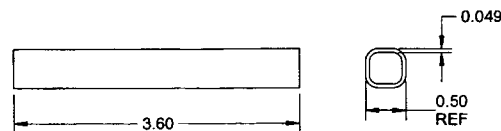


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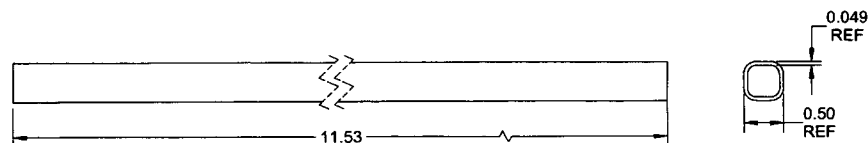
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.65 lbs
- 8) WELD PER DART QSI 004

D4785-101 TUBULAR ASSEMBLY, LH/RH

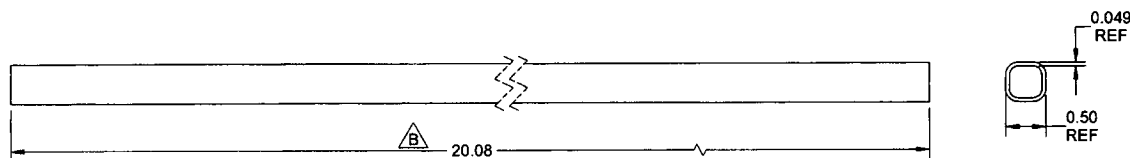
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DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	PC	D4785	SHEET 4 OF 7
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	LONG BASKET BASE ASSY	NTS
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D4785-1 RIB



D4785-3 RIB



D4785-5 RIB

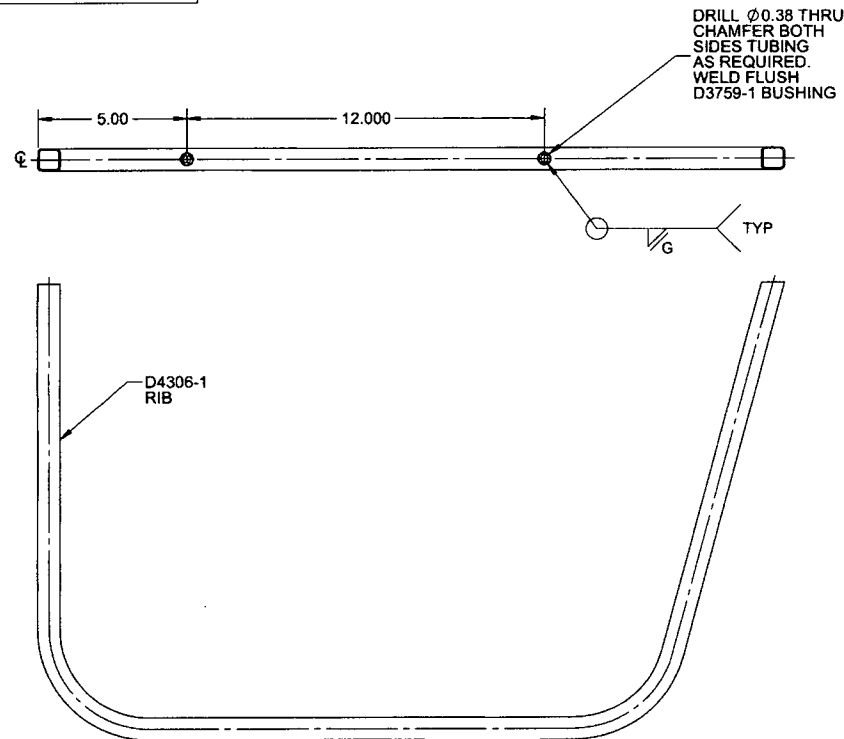
NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV/B
MFG. APPR.		D4785	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
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2013-06-20
MTP

ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

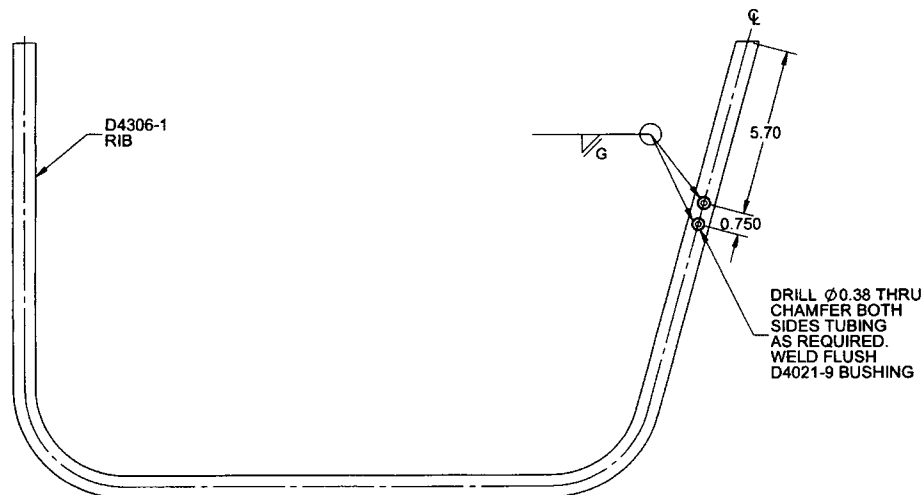
NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

RELEASED
2013-06-20
IND

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DL	DRAWING NO.	REV. B
MFG. APPR.	DL	D4785	SHEET 6 OF 7
APPROVED	DL	TITLE	SCALE
DE APPR.	DL	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING



D4785-117 RIB ASSEMBLY 
MAKE FROM D4306-1 RIB

RELEASED
2013-06-20
MP

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>IS</i>	D4785	SHEET 7 OF 7
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	LONG BASKET BASE ASSY	NTS
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